IZVEŠTAJ O ISPITIVANJU MAGNETSKIM ČESTICAMA
MAGNETIC PARTICLE TEST REPORT

LABORATORIJA ZA ISPITIVANJE BEZ RAZARANJA
LABORATORY FOR NONDESTRUCTIVE TESTING

Broj: *Number:*	**115/10MT/23**		
Strana: *Page:*	**1**	**Strana:** *Page:*	**7**

Izdaje: NDT-ZZ d.o.o. Beograd-Zemun, Tomice Popovića 26/2, tel/fax: 011/3753-782, mob:069/3321-939, e-mail: ndtzzoffice@gmail.com

Objekat: *Object:*	Objekat : Zeleznicka stanica Novi Sad Element : Nosaci staklene fasade		
Naručilac,adresa: *Purchaser,adress:*	PROFI INDUSTRIJA DOO za Starting d.o.o Beograd		
Predmet ispitivanja: *Object to be tested:*	Ugaono zavarenih spojeva na konstrukciji		
Zahtev naručioca: *Request of the purchaser:*	od 18.07.2023.god.	**Datum i mesto ispit.:** *Date and place of testing:*	22.07.2023.god.Ugrinovci

Oznaka/fabr. br.: *Identification/factory num.:*	H1,H3,H2,V1 i V2	**Vrsta spoja:** *Weld type:*	FW
Dimenzije(mm): *Dimension(mm):*	NA SKICAMA	**Postupak zavarivanja:** *Welding process:*	135
Izolacija: *Insulation:*	/	**Vreme eksploatacije:** *Service period:*	novo
Materijal/standard: *Material/Standard:*	S355 J2 /EN 10025	**Priprema površine:** *Surface preparation:*	Brušenjem grinding
Dodatni mat./standard: *Filler material/standard:*	BOEHLER EMK6 (Ø1,2 mm)/ EN ISO 14341-A	**Tehnika ispitivanja:** *Test technique:*	mokri-crno na belo wet -black on white
Interna oznaka: *Internal designation:*	/	**Napomena:** *Remark:*	

Ispitivanje prema: *Testing according to:*	SRPS EN ISO 17638	**Tehnika magnetisanja:** *Magnetization type:*	EM jaram
Temp.okoline: *Ambient temp.:*	25°C	**Obim ispitivanja:** *Scope of testing:*	100%
Ispitna strana: *Outside/inside surface:*	Spoljašnja Outside	**Jačina magnetnog polja:** *Magnetic field strength:*	>2kA/m
Struja magnetizacije: *Magnetization current:*	jednosmerna DC	**Osvetljenje:** *Illumination:*	Prirodno natural
Razmagnetisanje: *Demagnetization:*	ne	**Jačina struje:** *Current intensity:*	2,5 A

Uređaj (tip, oznaka / proizvođač) *Device (type, mark / manufacturer)*	EM jaram "TIEDE" - Germany	**Sredstvo za ispitivanje (tip, oznaka/proizvođač)** *Detection media (type, mark / manufacturer*	MR 158 "MR Chemie" - Nemačka

Nivo kvaliteta: *Quality level:*	EN ISO 5817 "C"	**Nivo prihvatljivosti:** *Acceptance level:*	SRPS EN 23278:2011- " 2X "

Ispitano *Tested*	**Vrsta spoja** *Weld type*	**Zavarivač** *Welder No.*	**Nalaz broj** *Indication No.*	**Parametri nalaza**/*Indication parameters*					**Prihvatljivo** *Acceptable*	**Ne prihvatljivo** *Not acceptable*	**Napomena** *Remark*
				Indikacija *Indication*	**Pozicija** *Position*	**Duž.** *Length*	**Dub.** *Depth*	**Pol.** *Location*			
					mm	mm	mm	*)			
MT1 4+4kom(H1+H3)	FW	/	/	BN/NF	/	/	/	/	X	/	
MT1 24 kom(H2)	FW	/	/	BN/NF	/	/	/	/	X	/	
MT2 7kom (V1)	FW	/	/	BN/NF	/	/	/	/	X	/	
MT3 7kom (V2)	FW	/	/	BN/NF	/	/	/	/	X	/	

*) OM – osnovni materijal/*parent material;* MŠ – metal šava/*weld metal;* ZUT – zona uticaja toplote/*heat-affected zone;* K – koreni zavar/*root run*;SŽ – stranica žljeba/*fusion face*; N – navareni sloj/*surfaced layer*

Napomena / *Note:*
Mestimično postoje zajedi minimalnih veličina koji zadovoljavaju dati kriterijum ispitivanja(vidi fot.)

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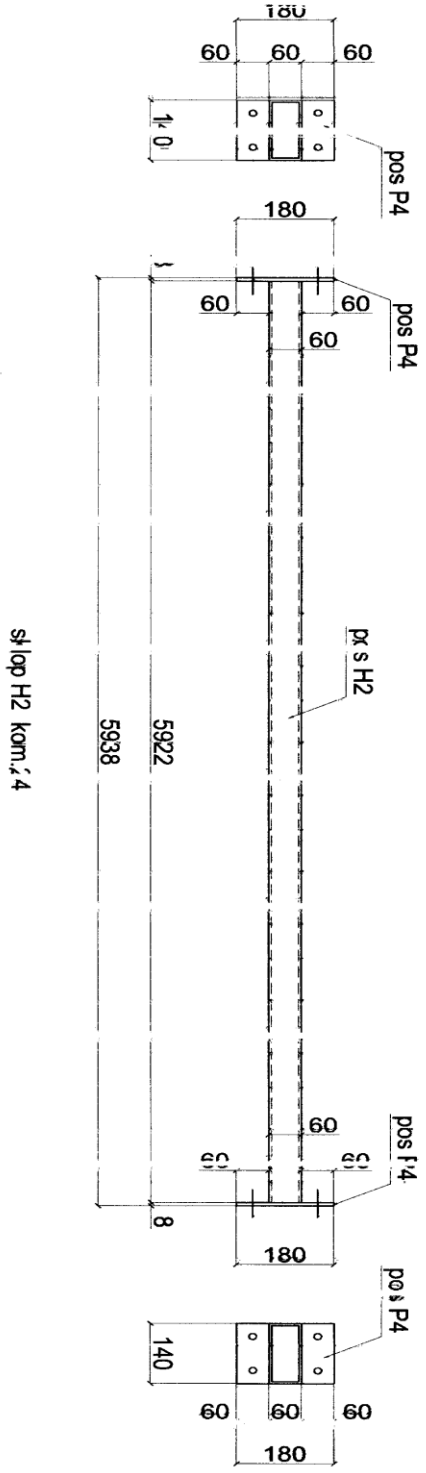

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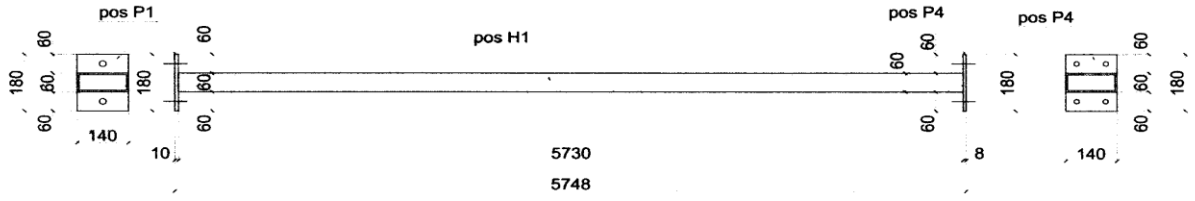
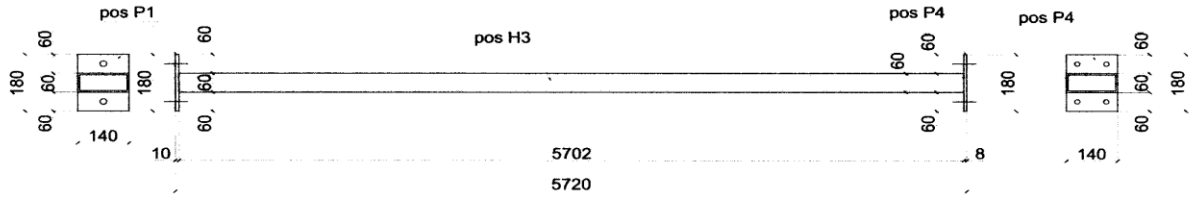


sklop H1 kom.4



sklop H3 kom.4

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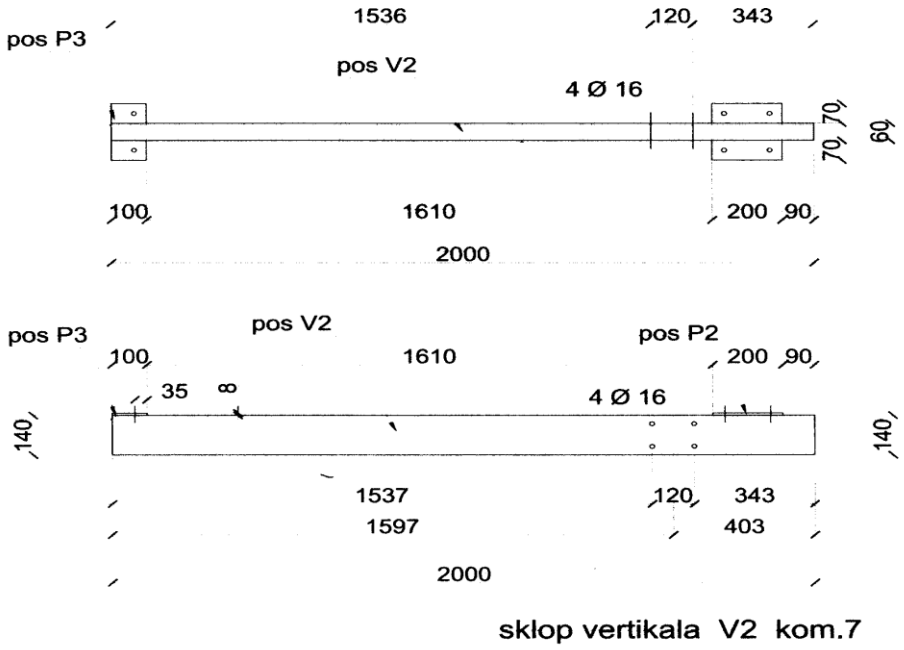

sklop vertikala V2 kom.7

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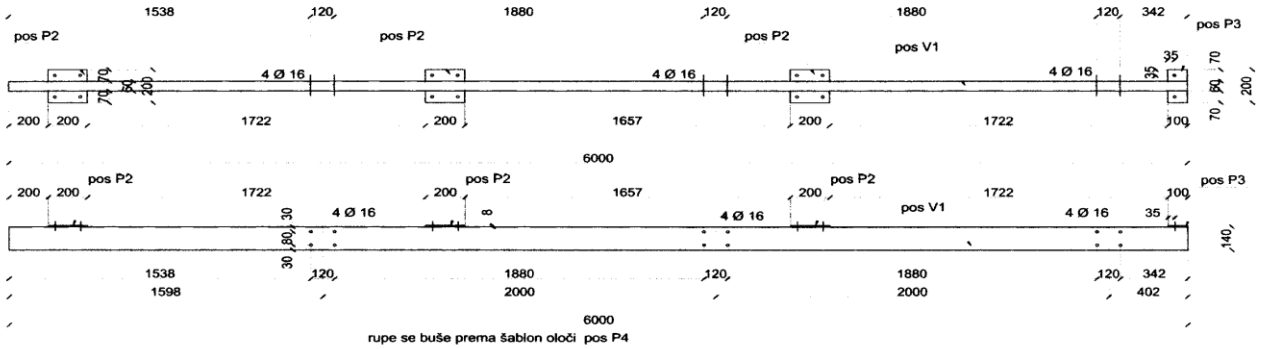

rupe se buše prema šablon oloči pos P4

sklop vertikala V1 kom.7

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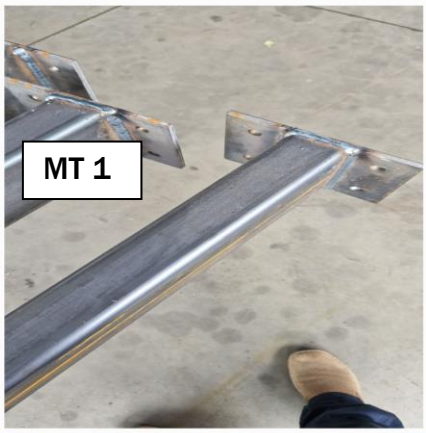
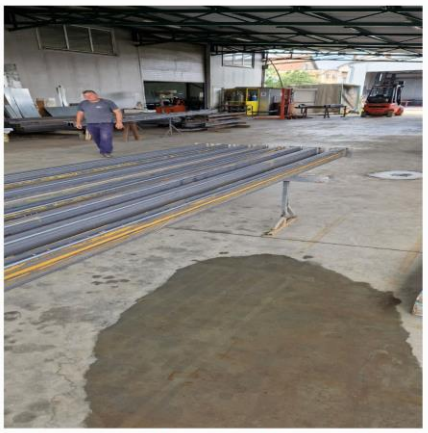
MT 1





MT 2

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MT 3

NDT ZZ d.o.o. Beograd-Zemun NDT Z Z

Mesto i datum *Place, Date*	Ispitao *Tested*	Overio *Verified by*	Odobrio *Approved by*
Beograd,24.07.2023.god	Ivan Mirosavljević I-090523/1-5/MT 2	Zagorac Zoran, IWT,IWI-C LEVEL 3 I-NDT 3-0100/16	Zagorac Jelena dipl.prav.

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